

Spit
Work Order ID 71707-1

Thursday, July 07, 2011 12:59:17 PM

Page 1

Item ID: D4022-041

Revision ID:

Item Name: Fuel Transfer Pump Assembly *41*

Start Date: 7/7/2011 Start Qty: 4.00

Required Date: 7/21/2011 Req'd Qty: 4.00

Reference:

Accept

Cust Item ID:

Customer:

Approvals: Process Plan: *CL*

QC:

Date: 11/07/07 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4022

A

0.00

0.00

0.00

0.00

0.00

0.00

100

Small Fab

Small Fab

Memo

assemble as per dwg D4022

Metal set A4 batch: *11/6/43*

QC5- Inspect part completeness to step on W/O

Memo

110

QC

Quality Control

120

Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

11-8-4
11-11-24 ①

⑩

11/24/11

5 11/24

71018
costed

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4022-041

Revision ID:

Item Name: Fuel Transfer Pump Assembly

Start Date: 7/7/2011 Start Qty: 4.00

Required Date: 7/21/2011 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/24

MF
11-11-24

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Picklist Print

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Page 1

Work Order ID: 71707

Parent Item: D4022-041

Parent Item Name: Fuel Transfer Pump Assembly



Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.02.02 new issue Prelim EC verified by:DD IPP Rev:B
10.05.17 as per ECN10-562 DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4022-1		Manufactured	No			100	Each	7.0000	1	4			
Fuel Transfer Pump													

Location	Loc Qty	Loc Code
----------	---------	----------

ST112	4	
67660	3	
67804	1	
ST139d	3	
67804	3	

D4022-5		Manufactured	No			100	Each	10.0000	1	4			
Thermal Switch													

Location	Loc Qty	Loc Code
----------	---------	----------

ENG	1	B72655
55518	1	
ST110	9	
64945	9	

AN815-6D		Purchased	No			100	Each	19.0000	2	8			
Union-M-Flare													

Location	Loc Qty	Loc Code
----------	---------	----------

ST329	19	
117514	3	
118090	16	

117 503
118 343

SB 11/05/01

~~11/05/01~~
already pulled on other

SB 11/03/04

0

4

SB 11/03/04

14
2

W/O:		WORK ORDER CHANGES					
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DOESN'T

Picklist Print

Thursday, July 07, 2011 12:59:14 PM

Page 2

Work Order ID: 71707

Parent Item: D4022-041

Parent Item Name: Fuel Transfer Pump Assembly



Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

MS29512-06

Purchased

No

100

Each

30.0000

2

8



SB 46307

O-RING

Location

Loc Qty

Loc Code

ST294

30

117946

20

118078

10

PI 116301

4
10
CH

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

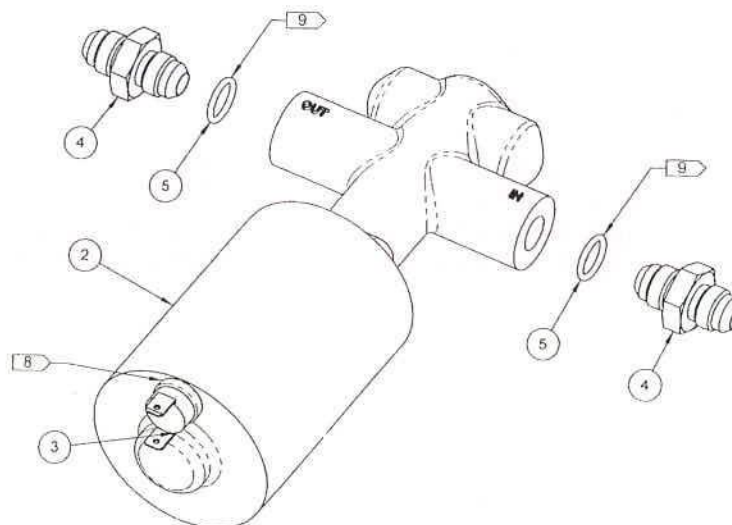
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4022-041	FUEL TRANSFER PUMP ASSEMBLY	A8150-B1-JCA
2	1	D4022-1	FUEL TRANSFER PUMP	
3	1	D4022-5	THERMAL SWITCH	
4	2	AN818-6D	FITTING, UNION	
5	2	MS29512-06	O RING	



D4022-041 FUEL TRANSFER PUMP ASSEMBLY

RELEASED
2010-05-05
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4022-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.61 lbs
- 8) ATTACH D4022-5 THERMAL SWITCH TO D4022-1 FUEL PUMP IN LOCATION SHOWN USING METALSET A4
- 9) LUBRICATE O-RING WITH ULTRACHEM ASSEMBLY FLUID #1, FUEL-LUBE, MOLYKOTE 55 O-RING GREASE OR EQUIVALENT

A	NEW ISSUE		10.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4022	REV. A
TITLE FUEL PUMP	SHEET 1 OF 4
	SCALE NTS
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Dart Aerospace Ltd

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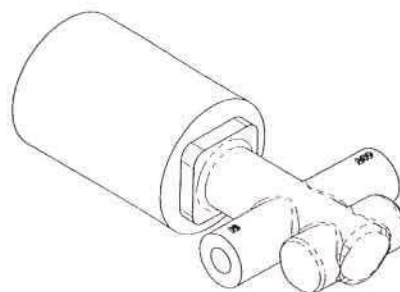
DART AEROSPACE
PART NUMBER

D4022-1

JOHN CAMERON AVIATION
PART NUMBER

REF JCA/M47/D3/SHT 13

SPECIFICATION CONTROL DRAWING



DART PART NUMBER	SUPPLIER	SUPPLIER PART NUMBER	OPERATING VOLTAGE	FLOW (GPH)	OUTPUT PRESSURE (PSI)	TEMPERATURE RANGE
D4022-1	WELDON	A8150-B1	24 VDC	35 - 50	5 - 25	-65°F TO +185°F
	AEROSPACE ACCESSORIES	A8150-B1	24 VDC	35 - 50	5 - 25	-65°F TO +185°F

D4022-X FUEL TRANSFER PUMP

RELEASED
2010-05-05
AM

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.6 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO D4022	SHEET 2 OF 4
DATE	10.04.16	TITLE FUEL PUMP	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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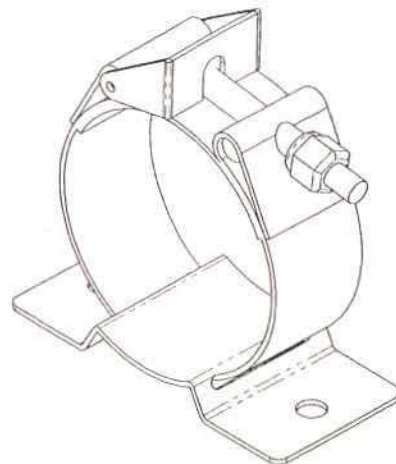
DART AEROSPACE
PART NUMBER

D4022-3

JOHN CAMERON AVIATION
PART NUMBER

REF JCA/M47/D3/SHT 13

SPECIFICATION CONTROL DRAWING



DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	MATERIAL	FITS MOTOR SIZE (ϕ)
D4022-3	WELDON	TC 250-100	STAINLESS STEEL	2.5
	AIRCRAFT SPRUCE AND SPECIALTY	05-00021	STAINLESS STEEL	2.5
	AEROSPACE ACCESSORIES	TC 250-100	STAINLESS STEEL	2.5

D4022-X FUEL PUMP MOUNTING BRACKET

RELEASED
2010-05-05

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO D4022 TITLE FUEL PUMP SCALE NTS
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MFG. APPR.		
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DATE	10.04.16	

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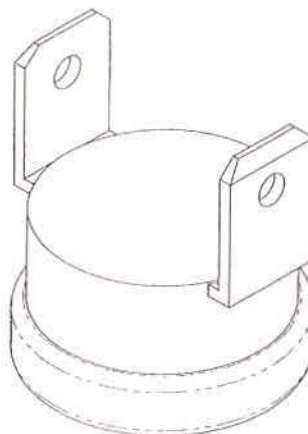
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4022-5	REF JCA/M47/D3/SHT 13

SPECIFICATION CONTROL DRAWING



DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	ALTERNATE PART NUMBER	TEMPERATURE WHEN SWITCH OPENS
D4022-5	FARNELL	1006847	3775628	125°F
	HONEST-WELL	T23A125BSR2-15	3775628	125°F
	NEWARK	98K1992	3775628	125°F

D4022-X THERMAL SWITCH

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

RELEASED
2010-05-05
mp

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DESIGN		DRAWING NO D4022
DRAWN		
CHECKED		TITLE FUEL PUMP
MFG. APPR		
APPROVED		SHEET 4 OF 4
DE APPR		SCALE
DATE	10.04.16	NTS
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